



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE1X53-166-817
Job Sheet 189481



Part No: RBE1X53-166-817

Job Qty: 2 pcs

Part Name: PULLER



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/24/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE1X53-166-817 Rev.2 IPP Rev. A 19.01.07 New issue DP Verify DD

Ship Via:



Container No: S169466



Part: RBE1X53-166-817

Job No: 189481

Serial No/Batch: S169466

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/04/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/8/19		0.00	0.40	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	3/8/19		0.00	0.00	QC 5 - 10		DAS APR 04 2019 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	2 pcs	3/8/19		0.00	0.00	Packaging 3 - 1 - B4B		MLC
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	2 pcs	3/8/19		0.00	0.00	QC 21 - FG - 21		MLC
Part Op 100 - Assemble as per DWG. Descriptions: 110 - (QC5- Inspect part completeness to step on W/O) 120 - (Identify as per dwg & Stock Location: _____) 130 - (QC21- Final Inspection - Work Order Release)									DAS 21 9-89 APR 04 2019

Job BOM

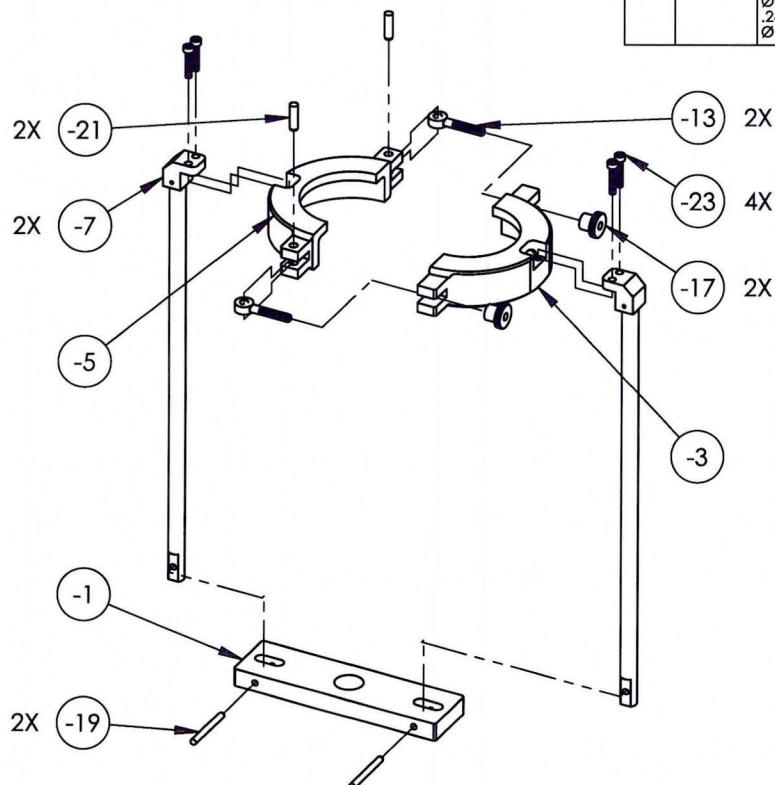
Part / Item	Component Name	Quantity	Operation	Container
36 3799K13	Rod End, M8 x 1.25 X 50mm	4 Ea (2 ea)	100-Small Fab - 1	5144292
44 60765K343	Knob, M8 x 1.25	4 Ea (2 ea)	100-Small Fab - 1	5144295
66 91290A332	Screw, M6 X 30mm SHCS	8 Ea (4 ea)	100-Small Fab - 1	5144303
67 91595A485	Dowel Pin, 6mm X 60mm	4 Ea (2 ea)	100-Small Fab - 1	5144304
67 91595A567	Dowel Pin, 8mm X 30mm	4 Ea (2 ea)	100-Small Fab - 1	5144306
133 RBE1X53-166-817-1	Base Plate	2 pcs (1 ea)	100-Small Fab - 1	5157311
137A RBE1X53-166-817-3	Ring	2 pcs (1 ea)	100-Small Fab - 1	5150879
RBE1X53-166-817-5	Ring 2	2 pcs (1 ea)	100-Small Fab - 1	5151098
133 RBE1X53-166-817-7	Weldment	4 pcs (2 ea)	100-Small Fab - 1	5159955

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3799K13	4	6	0
	60765K343	4	10	0
	91290A332	8	50	0
	91595A485	4	10	0
	91595A567	4	10	0
	RBE1X53-166-817-1	2	0	0
	RBE1X53-166-817-3	2	0	0
	RBE1X53-166-817-5	2	0	0
	RBE1X53-166-817-7	4	0	0
Part Specifications				
Specifications could not be found.				

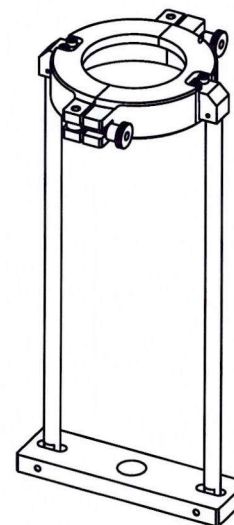
Plex 1/24/19 3:07 PM Dart.lajeunesse.marie

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2	16-0220	ADDED NOTE 1 SHEET 1. -1, -3, -5, -7 ADDED FINISH QMSI-6.2.2, B.O. REV D. -1, -7 CH'D MATERIAL WAS 1018 IS A36/1018/1020 HR. -1 CH'D DIM WAS 2X Ø .2362/.2358 THRU ALL IS 2X Ø.2382/.2375 (S.F. -19). WAS 8.650 IS 8.65. WAS 2.360 IS 2.36. WAS .750 IS .75. -3, -5 CH'D MATERIAL WAS 4140 IS 4140/4142. ADDED HEAT TREAT RC 28-34. -3 CH'D DIM WAS 2X .770 IS 2X .77. ADDED DIM 2X .91. ADDED ENGRAVE NOTE. -5 CH'D DIM WAS 2X .770 IS 2X .77. ADDED DIM 2X .453 ±.010, 2X .91. ADDED ENGRAVE NOTE. -7 CH'D DWG. TO SHEET METAL TOLERANCE. -9 CH'D DIM WAS .129/.125 IS Ø.129/.125 (P.F. -15). WAS Ø.625 ±.005/.000 T. 510 IS Ø.625 ±.005/.000 T. 51 (S.F. -11). WAS 2.40 IS 2X 2.40. DELETED DIM .395. -11 CH'D DIM WAS Ø(.625) IS Ø.63. WAS 1.200 IS 1.20. WAS .600 IS .60. WAS Ø.2391/.2379 THRU ALL IS Ø.2362/.2357 THRU ALL (P.F. -19). ADDED DIM .56 Ø.620/.615 (S.F. -9).	11/14/2016	RJC	SM	



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WITHOUT NOTICE
WORK ORDER
NO. 189481 MJS
18-01-24



- NOTES:
1. REF. EUROCOPTER T/N 1X53 166 817.
2. USED IN KIT RBEA62316

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE PLATE	A36/1018/1020 HR		2
			-3	1	RING	4140/4142		3
			-5	1	RING 2	4140/4142		4
X			-7	2	WELDMENT			5
1			-9		ROD TOP	A36/1018/1020 HR		6
1			-11		ROD	1018/1020 CR		7
		B/O	-13	2	ROD END	STEEL	M8 x 1.25 X 50mm (MCMaster-CARR #3799K13)	1
		B/O	-15	2	SPRING PIN	STEEL	Ø1/8 X 7/8 (MCMaster-CARR #90692A699)	5
		B/O	-17	2	KNOB	STEEL	M8 x 1.25 (MCMaster-CARR #60765K343)	1
		B/O	-19	2	DOWEL PIN	STEEL	6mm X 60mm (MCMaster-CARR #91595A485)	1
		B/O	-21	2	DOWEL PIN	STEEL	8mm X 30 mm (MCMaster-CARR #91595A567)	1
		B/O	-23	4	SCREW	STEEL	M6 X 1 X 30mm SHCS (MCMaster-CARR #91290A332)	1
ASSY -7								

		TITLE	
		PULLER	
DWG NO.		REV	
RBE1X53-166-817		2	
MAT'L		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
		.X ± .1 SURFACES = 125/	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES	
CHECKED: DUERFELDT		.015 x 45° OR .015R	
OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY		AFTER PLATING	
APPROVED: MACKOVJAK		3. INTERPRET DIM AND TOL PER	
SCALE 1:7		ASME Y14.5M-2009	
DATE 6/18/2012		USED ON MODEL	
		EC135	
		SHEET 1 OF 7	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					